

71 5/06

SPLIT

DART AEROSPACE LTD	Work Order:	22170 B
Description: Wearplate	Part Number:	D2577-3
Dwg: D2577 Rev. E	Qty:	12 50
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	HA	05.01.12	50
2	PG	Issue P/O: 2007409 Email or Ship DXF file to vendor Laser Cut per Dwg D2577 flat pattern D2577-101 Material release note required	U	05.01.12	50
3	RG	Receive and Inspect for transit damage Ensure that material release note is attached	CL	05.01.31	50
4	QC6	Inspect dimensions per template D2577-101T1	2	05.04.21	50
5	GB	Debur if necessary	N/A		
6	GB	Form on brake as per Dwg D2577 using DT8155 and DT8178 Identify as D2577-3	HA	05.4.21	50
7	QC5	Inspect work to Step 6	HA	05/04/21	50
8	WS	Weld hard surface using DT8308A & DT838B as per Dwg D2577 Qty Description Batch A/R 7560 Hardcoat Rod M16901 M16234	HA	05/04/26	12
9	QC9	Inspect weld	HA	05/04/26	12
10	FP	Powder Coat Grey (Ref.4.3.5.6) per QSI 005 4.3	FF	05/5/5	12
11	QC3	Inspect Powder Coat	MM	05 05 05	12
12	FP	Identify and Stock	FF	05/5/5	12
13	AC	Cost / part 26.75	SAC	05.05.06	12
14	DC	Close W/O 26.13 Inspect Level 21	HA	05.05.09	12

Rev	Date	Change	Revised By	Approved
A	96.08.20	New Issue		
B	98.04.15	Changed finish detail, changed forming sub-contractor	KB	
C	99.02.02	Added inspection levels, Jig numbers	DM	
D	00.10.02	Reformat	EC	
E	01.06.08	Powder coat in house and went back to laser cut.	EC	
F	02.09.24	Re-format; Incorporated D2577-101/-13	KJ RF	

RELEASED
02/10/02 RF



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 3755 555 Auckland
(06) 2358 000 Waikato
Fax: (09) 3755 059 Toller: 24826

TEST CERTIFICATE

Ref: 3228/1122

CUSTOMER	Wilkinson	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC065404
CUSTOMER ORN	90-21N-828	PRODUCT	CRA WIRE COIL	PAGE	1 of 1
MILL ORN	357274	DIMENSIONS	0.055" x 40" x Coil	DATE	08 April 2003

PACK NUMBER	CHEMICAL COMPOSITION PERCENT																	MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)					
	HEAT No	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CEI	BEND 180°	YIELD	T.S.	%ELONG	HARDNESS	LENGTH (feet)
		x100	x1000	x10000	x100	G.L.	HRB	()															
R9-404632-00	622644	4	TR	17	12	16												Good				47	1539
R9-404633-00	622644	4	TR	17	12	16												Good				47	1512
R9-404634-00	622652	4	TR	20	12	14												Good				50	1588
R9-404635-00	622652	4	TR	20	12	14												Good				50	1568
R9-404636-00	622652	4	TR	20	12	14												Good				48	1506
R9-404637-00	622652	4	TR	20	12	14												Good				48	1499

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
[A]=0.2% PROOF STRESS	[A]=200mm [C]=80mm [E]=2"	[A]=0 [C]=45	[A]=10mm x 10mm	[A]=C+Mn/5
[B]=LOWER YIELD STRESS	[B]=50mm [D]=5.65 / So [F]=8"	[B]=190 [D]=(rD+100+2/45) / 4	[B]=7.5mm x 10mm	[B]=C+Mn/5+(Cr+V+Mo)/5+(Cu+Ni)/15
			[C]=5mm x 5mm [D]=2.5mm x 10mm [E]=5mm x 10mm	[C]=C+Mn/5+Si/24 [D]=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST

16 ga coils

